

Date: Monday, 02/03/2009 9:05:16 AM
User: Julie Dawson

Process Sheet

Split

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEP WELDMENT
Job Number	: 46148-2	Part Number	: D34631
Estimate Number	: 10698	Drawing Number	: D3463 REV B
P.O. Number	:	Project Number	: N/A
This Issue	: 02/03/2009 S.O. No. :	Drawing Revision	: B
Prsht Rev.	: NC	Material	:
First Issue	: 1/1 Type : SMALL /MED FAB	Due Date	: 16/03/2009
Previous Run	: 44794	Qty:	1/1 Um: Each
Written By	:		
Checked & Approved By	: JUD 09.03.02		
Comment	: EST REV. A 05.11.17 NEW ISSUE EC		

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M316TR100W120

316 RD tubing 1.00 x .120w



Comment: Qty.: 2.1872 f(s)/Unit Total : 21.8715 f(s)

AISI 316 SS seamless tubing 1.00" OD X 0.120 wall

(M316TR1.00w120)

Batch:

M110672

(21872)

4,3744

M111096

(2X)

M111054

(36X)

78.73

2.0

BAND SAW

BAND SAW



Comment: BAND SAW

Cut blank 25.00 " long

m-1 09/03/16

3.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Bend as per dwg D3463

→

FF 09/03/23

2-Trim to length per dwg D3463

→

3- Deburr

EL 9-3-23

/M.A 09/03/19

4.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ensure 90 deg angle is within tol. (+/-0.5deg) critical dim.

09/03/23 (+37)

5.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE




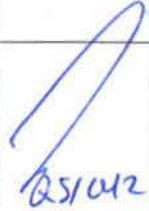
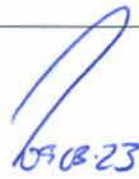
Comment: CONVENTIONAL MILLING MACHINE

1- Drill as per dwg D3463

M.A 09/03/19

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: D3463-1 PAR #: N/A Fault Category: Prod / FAB. Assy needed small NCR: Yes No DQA: D Date: 09/03/26
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: D Date: 09/03/26

NCR: <u>46148</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
0903.23	3.0	1 part is kinked from bending. Scrap RC: process.		- Scrap & destroy No replace qty 1	SB 09/03/23	S 09/03/23		

NOTE: Date & initial all entries

Date: Monday, 02/03/2009 9:05:16 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 46148

Part Number: D34631

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Deburr as per dwg D3463

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

HA 09/03/19

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

502/03/23 counter (X32)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: W/A CARL'S BOOTH

EL 9-3-23 X37

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/24 JF

Job Completion



MF 09-03-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

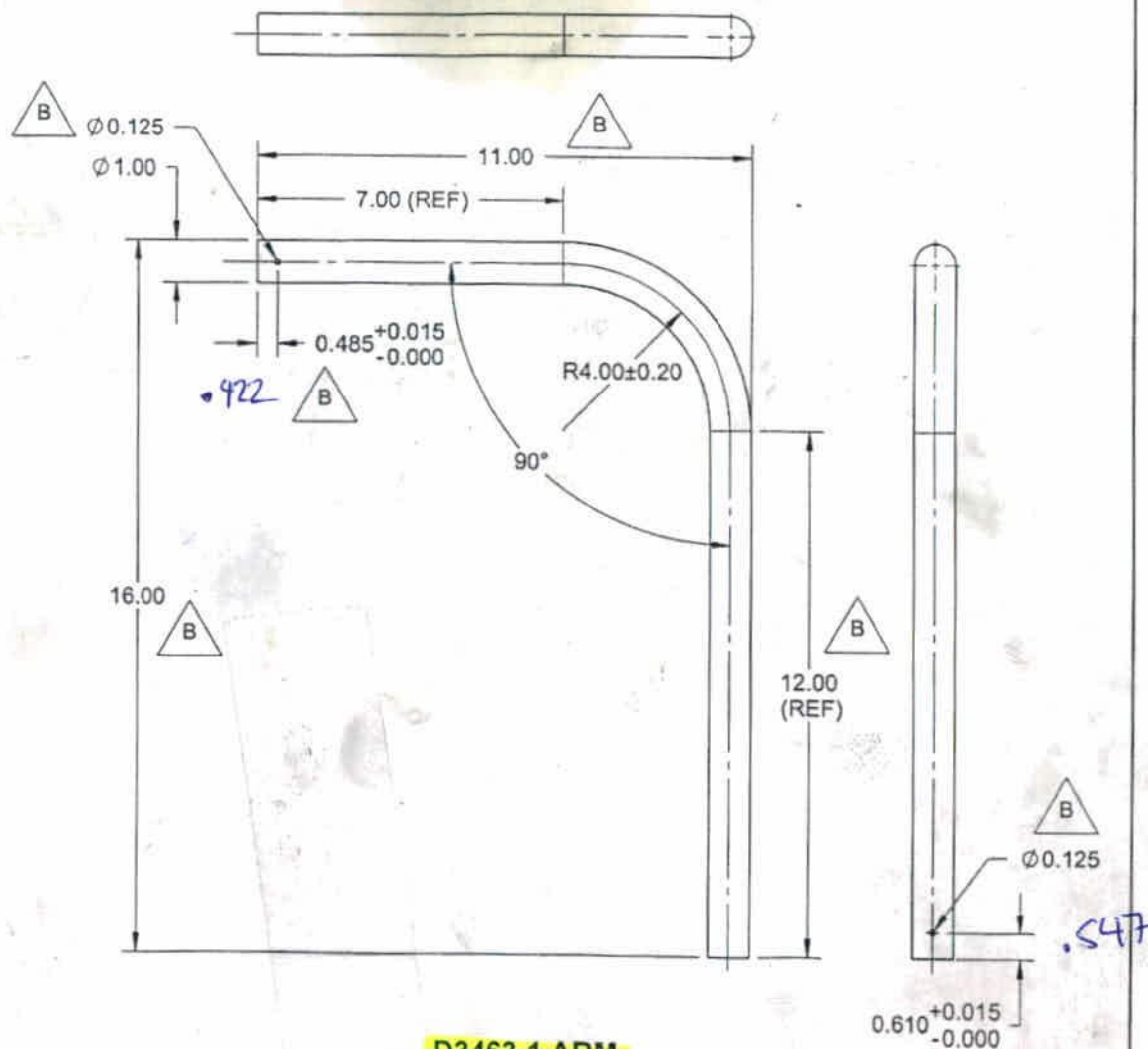
NOTE: Date & initial all entries

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3463	REV. B SHEET 2 OF 4
DATE 05.12.05	TITLE STEP WELDMENT		SCALE 1:4

RELEASED

05.12.05

**D3463-1 ARM****NOTES:**

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR1.000W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 4048

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